Thursday, 4/12/2007 8:46:25 AM

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 31735

Estimate Number

: 10452

P.O. Number

This Issue

Prsht Rev.

First Issue

Previous Run

: N/A

: 4/12/2007

S.O. No. : N/A

: MACHINED PARTS

: 31661A

Written By Checked & Approved By

Comment

New issue KJ/JLM : Est:A

Drawing Name

: SUPPORT

Part Number

Drawing Number

: D32781 : D3278 REV. B

Project Number

: N/A

Drawing Revision Material

Due Date

: 5/5/2007

Qty:

60 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

M6061T6B1000X02000

6061-T6 Bar 1.0" x 2.0"

Comment: Qty.:

0.2454 f(s)/Unit Total:

14.7231 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000)

Batch: <u>MAQ95</u>

2.0

SHEAR



Comment: SHEAR

Cut blank: 2.00" x 1.00" x 2.550" long

HAAS CNC VERTICAL MACHINING #1

3.0

HAAS1

Comment: HAAS CNC VERTICAL MACHINING #1

- 1- Machine'as per Folio FA405 and Dwg D3278
- 2- Deburr and Tumble

Identify as D3278-1

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACH



PARTS AS THEY COME OFF MACHINE

QC8

SECOND CHECK

5.0

Comment: SECOND CHECK

Page 1

Form: rorocess

Dart Ae	rospace L	td				•		
W/O:			WC	ORK ORDER CHANGES				
DATE	STEP	STEP PRO		ROCEDURE CHANGE		Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						:		
				•				
Part No	•	PAR #:	Fault Cate	gory:NO	R: Yes (No DQA:	Date: (57/04/27
					QA: N/	C Closed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMANC	E (NCR)		
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector

NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC	ription of NC Corrective Action Section B			Varification	Approval				
DATE	STEP	Section A Initial	Initial Chief Eng			Sign & Section C		Approval QC Inspector			
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		•									
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	1							1			

NOTE: Date & initial all entries

Thursday, 4/12/2007 8:46:25 AM Date: • Kim Johnston **Process Sheet** User: **Drawing Name: SUPPORT** Customer: CU-DAR001 Dart Helicopters Services Job Number: 31735 Part Number: D32781 Job Number: Description: Seq. #: Machine Or Operation: HAND FINISHING RESOURCE #1 HAND FINISHING1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 POWDER COATING 7.0 M103 706 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 Comment: INSPECT POWDER COAT PACKAGING RESOURCE Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FINAL INSPECTION/W/O RELEASE 10.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

Dail AC	105pace Ltu								
W/O:			WORK ORDE	R CHANGES					
DATE	STEP	PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							r		
-				gar.				:	
Part No	•	PAR #:	Fault Category:	N	CR: Yes	No DG	QA:	Date: _	
					QA:	N/C Close	ed:	Date: _	
NCR:			WORK ORDER NON-CO	ONFORMANO	E (NC	R)			
			Corrective Ac	tion Section B					,

NCR:		`	WORK ORD	ER NON-CONFORMANO	CE (NCR)			
•		Description of NC		Corrective Action Section B			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector
		N.						
		•						

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31735
Description: Support	3	Part Number:	D3278-1
Inspection Dwg: D3278 Rev: B			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X F	irst Article		Prototype
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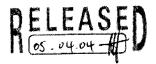
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	3 099	1			
0.359	+/-0.005	359	1			
(d) 0.615	+/-0.010	615	/_			
0.250	+/-0.010	. 250				
1.480	+/-0.005	1.480	/			
R0.125	+/-0.010	.125				
0.119	+0.005/-0.004	-120				
2.439	+/-0.010	2.438				
1.980	+/-0.010	1.981				
R0.130	+/-0.010	.130_				
Ø0.257	+0.005/-0.000	.259	_/_			
R0.375	+/-0.010	-375				
0.875	+/-0.010	875				
0.500	+/-0.010	.500				
R0.400	+/-0.010	-400				
1.720	+/-0.010	1.721	/			,
R0.125	+/-0.010	.125	/,			
0.125	+/-0.010	./27				
		; !				

Measured by:	Audited by:	and	Prototype Approval:	N/A
Date: 07/04/19	Date:	07/04/19	Date:	N/A

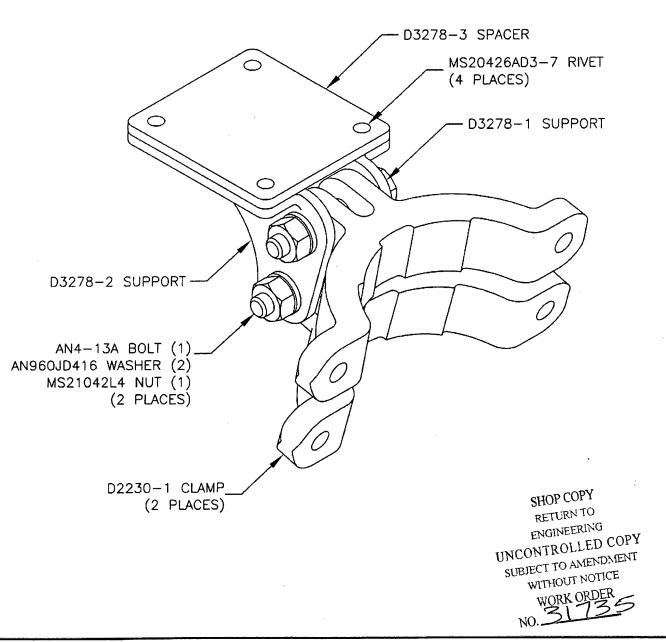
Rev	Date	Change	Revised by	Approved
Α	04.04.19	New Issue P/O D3278-041	KJ/JLM LA	
В	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
	I			7~7



	DESIG	CP	DRAWN BY	DART AEROSPACE LT HAWKESBURY, ONTARIO, CANADA	ΓD
-	CHECK	KED "/	APPROVED ,	DRAWING NO.	REV. B
	l	W	一世	D3278 sh	HEET 1 OF 3
	DATE		<u> </u>	TITLE	SCALE
	05.0	03.31		SUPPORT ASSEMBLY	NTS
	Α		04.03.03	NEW ISSUE	
	В		05.03.31	CHANGE DIM/TOL TO ENSURE FI	ıT



D3278-041 SUPPORT ASSEMBLY

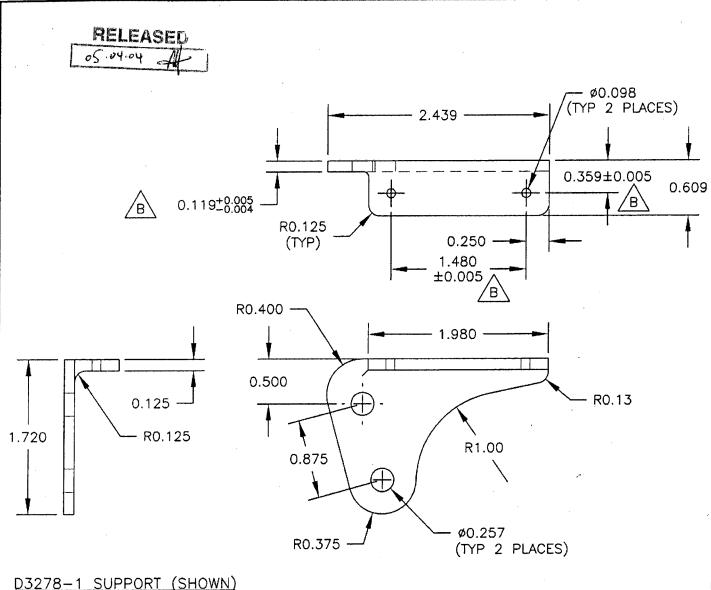


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#	#	D3278		SHEET 2 OF 3
DATE		TITLE		SCALE
05.03.31		SUPPORT A	ASSEMBLY	1:1



D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/8) (REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

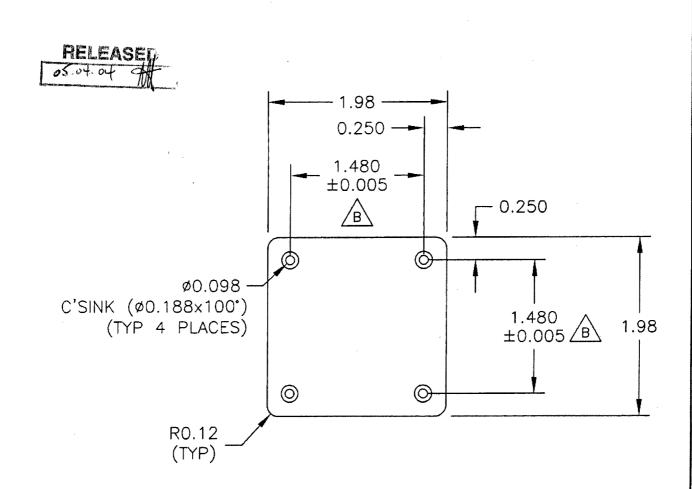
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#	一世	D3278		SHEET 3 OF 3
DATE		TITLE		SCALE
05.03.31		SUPPORT	ASSEMBLY	1:1



D3278-3 SPACER

1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR MIGREFRING O.125 THICK

2) REFERENCE OF THE STREET OF

2) BREAK ALL SHARP EDGES 0.005 TO 0.015

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

4) ALL DIMENSIONS ARE IN INCHES.

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